

# Work Order ID 118923

Tuesday, May 06, 2014 10:16:51 AM

**\*118923\***

Page 1

Item ID: D350-636-018 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible  
 Start Date: 5/15/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 5/20/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 14-05-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4168-044	B								
100	Document Control	0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D350-636-018 CHG 005								

DAS  
31  
9-89

12 14-05-28

FWD BEND 89.5° BE 14-05-08

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width:33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width:33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width:33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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**Work Order ID 118923**

Tuesday, May 06, 2014 10:16:51 AM

**\*118923\***

Page 2

Item ID: D350-636-018

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 5/20/14 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

**\*110\***

Skidtubes

Skidtubes

0.00

0.00

**Memo**

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

**\*\*\*ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE\*\*\***

Drill pilot holes using drill Jig DT8150 &amp; DT8864A for first side only DT8864B for second side section BE-BE and BC-BC

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616 detail AA . Ensure proper positioning.

6-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.

7-Open up holes of Detail A to 0.297" (total of 2 holes per side) +.201"(total of 1 hole per side)

8-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004

*3E14-05-08*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Work Order ID 118923

Tuesday, May 06, 2014 10:16:51 AM

**\*118923\***

Page 3

Item ID: D350-636-018 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID:  
Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible Stop **\*NS2\***  
Start Date: 5/15/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 5/20/14 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch: <i>m128385</i>								
	9-Grind welds flush as per Dwg D4168								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

*D 140509* **DAS 9 9-89**  
*D 14-05-09* **DAS 9 9-89**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 118923****\*118923\***

Page 4

Item ID: D350-636-018

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 5/20/14 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:


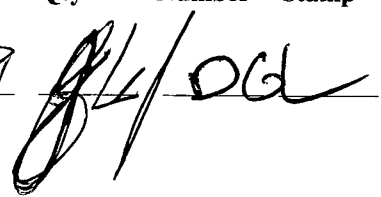

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

14-59   02/14/05/12

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Handling/Pre									
Material									
Operator									
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Process									
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Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 118923

**\*118923\***

Page 5

Item ID: D350-636-018

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Stop **\*NS2\***

Start Date: 5/15/14 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 5/20/14 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Open up holes using hole saw of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.								
	2-Open up holes of wearplate holes to 0.375" section CK-CK (total of 4 holes per side) 0.3125" holes section BC-BC (4 per side) as per dwg D4168.								
	3- Open float using uni-bit hole to 0.500" (4 per side)								
	4-Chamfer holes dwg D4168 (welding instructions on sheet 11)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI015 let cure for 12hrs. A/R Sikaflex-291 batch: <u>128569</u> exp. date: <u>14/11/02</u>								
	8- Weld spacers as per dwg D4168 & QSI004 (welding instructions on sheet 11) A/R Aluminum Rod batch: <u>m27763</u>								
	9- Grind welds flush as per Dwg D4168								
	10-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168								

DC 14/05/12

8 E14-05-14

14-5-15 DL/DL

DP 14-5-21

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 118923

\*118923\*

Page 6

Tuesday, May 06, 2014 10:16:51 AM

Item ID: D350-636-018 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible  
Start Date: 5/15/14 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 5/20/14 Req'd Qty: 2.00 \*2\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11- C'bore section CK-CK. ADJUST TOOLING AS REQUIRED. VERF BY: <u>                    </u>								
	12- Deburr holes, ensure tube is free of all scratches before sending to paint.								
	***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** *****REF TO W/O BATCH: _____*****								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
*170*	Memo	0.00							
QC									
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
*180*	Memo	0.00							
QC									
Quality Control									

14-5-21

Shp  
4/15/20

Shp  
4/15/20

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 118923

**\*118923\***

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Tuesday, May 06, 2014 10:16:51 AM

Item ID: D350-636-018 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible  
 Start Date: 5/15/14 Start Qty: 2.00 \*?  
 Required Date: 5/20/14 Req'd Qty: 2.00 \*?  
 Cust Item ID:  
 Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	76	14-5-22	
<b>*100*</b>									
Hand Finish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
<b>*200*</b>						1	CR	14-05-25	
Spray Paint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>128975</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>129174</u>								
210	QC14- Inspect Spray Paint	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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15  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Work Order ID 118923

\*118923\*

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Tuesday, May 06, 2014 10:16:51 AM

Item ID: D350-636-018 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible  
 Start Date: 5/15/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 5/20/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
*230*	Memo	0.00							
Hand Finish	1- Install inserts as per Dwg D4168								
Hand Finishing	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: M1128569								
	EXP DATE: 14/10								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: 14121651								
	5-Coat all exposed fasteners with "LPS Procyon" batch: 14 127900								
240	QC5- Inspect part completeness to step on W/O	0.00							
*240*	Memo	0.00							
QC									
Quality Control									

1RH f 14 140126  
~~NAS11611-005~~  
 NAS1611-005/126974 x8  
 NAS1611-010 / M128375 x8  
 PLM 14-06-03

DAS  
 27  
 9-89  
 14/5/27

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 118923

**\*118923\***

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Tuesday, May 06, 2014 10:16:51 AM

Item ID: D350-636-018 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible  
 Start Date: 5/15/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 5/20/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270	Packaging	0.00							
<b>*270*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-018								
	Location: _____								
	PPP rev: _____								

JUN 25 2014

DAS  
06  
9-89

DAS  
26  
9-89

DAS  
31  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 118923

\*118923\*

Page 10

Tuesday, May 06, 2014 10:16:51 AM

Item ID: D350-636-018

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Stop

\*NS2\*

Start Date: 5/15/14

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 5/20/14

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

\*280\*

QC

Memo

0.00

Quality Control

MLJ 14-06-26

14-6-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
--	--	---	--

# Picklist Print

May-12-14 11:52:26 AM

Page 1

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B  
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per  
NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-  
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD  
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C34A		Purchased	No			230	Each	40.0000	1	1			
<b>*AN3C34A*</b>									<b>**</b>				
BOLT													

Location Loc Qty Loc Code

ST352 40  
m127044 40

AN3C36A		Purchased	No			230	Each	198.0000	4	4			
<b>*AN3C36A*</b>									<b>**</b>				
Bolt													

Location Loc Qty Loc Code

FG 25  
101261 4  
122204 11  
124827 10  
ST514 173  
m127769 17  
m128398 81  
m128773 75

HL 11/05/26

HL 11/05/26

XL

# Picklist Print

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May-12-14 11:52:26 AM

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

AN3C37A

Purchased

No

230

Each

403.0000

1

1

Start Qty: 1.00

Required Qty: 1.00

**\*AN3C37A\***

BOLT

\*\*

DAS

26

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST353

10

M124131

1

M127823

9

ST514

393

M128491

193

M128773

200

/X

AN3C42A

Purchased

No

230

Each

49.0000

1

1

**\*AN3C42A\***

Bolt

\*\*

14-5-27

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

5

121103

5

ST353

44

m127300

1

m128491

18

m128830

25

/X

D3488-042

Manufactured

No

230

Each

17.0000

1

1

**\*D3488-042\***

Blade Fitting RH

\*\*

gl 11/05/20

Location

Loc Qty

Loc Code

FP001

7

113592

6

98887

1

FP002

10

112237

10

X1

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Shop Packet Print

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# Picklist Print

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Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

D3490-1	Manufactured	No	160	Each	171.0000	4	4	Start Qty: 1.00	Required Qty: 1.00
<b>*D3490-1*</b>								**	BE14-05-14
Cross Bolt Spacer									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	171	
112737	1	
(16358)	170	

D3490-5	Manufactured	No	230	Each	72.0000	4	4	**	BE14-05-14
<b>*D3490-5*</b>									
Cross Bolt Spacer									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG001	72	
(104851)	31	
109104	41	

D3492-1	Manufactured	No	230	Each	217.0000	8	8	**	14/05/14
<b>*D3492-1*</b>									
Plug									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	217	
111578	2	
112738	46	
114879	169	

D3492-5	Manufactured	No	230	Each	169.0000	8	8	**	14/05/14
<b>*D3492-5*</b>									
Plug									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	169	
104854	9	
105612	79	
112740	81	

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Shop Packet Print

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# Picklist Print

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Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

D3873-1

Manufactured No

230

Each

Start Qty: 1.00  
274.0000 7 7

Required Qty: 1.00

**\*D3873-1\***

Bushing

\*\*

*ml 11/05/26*

Location

Loc Qty

Loc Code

ST067

274

104858

5

105611

268

109110

1

*x7*

D4154-041

Manufactured No

230

Each

5.0000 1 1

**\*D4154-041\***

Wearplate Assembly

\*\*

*ml 11/05/26*

Location

Loc Qty

Loc Code

FP002

5

106716

1

114212

4

*B112322*

*x1*

D4170-1

Manufactured No

230

Each

133.0000 4 4

**\*D4170-1\***

Bushing

\*\*

*BE1405-14*

Location

Loc Qty

Loc Code

LG

12

111576

12

LG001

121

*107896*

121

*4*

D4171-1

Manufactured No

230

Each

22.0000 1 1

**\*D4171-1\***

Bushing

\*\*

*ml 11/05/26*

Location

Loc Qty

Loc Code

ST098

22

109144

22

*x1*

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Shop Packet Print

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# Picklist Print

May-12-14 11:52:27 AM

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/15/14

Required Date: 5/20/14

MS21043-3

Purchased

No

230

Each

616.0000

Start Qty: 1.00

Required Qty: 1.00

5 5

**\*MS21043-3\***

\*\*

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

39

124555

27

m126741

12

ST509

497

m128398

497

NAS1149C0363R

Purchased

No

230

Each

1,345.000

9

9

**\*NAS1149C0363R\***

\*\*

Washer

Location

Loc Qty

Loc Code

FP001

632

114742

632

Return2014

6

114742

6

ST292

707

122441

107

m128591

600

# Picklist Print

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Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

NAS1149D0863J

Purchased

No

250

Each

Start Qty: 1.00  
881.0000 2 2

Required Qty: 1.00

**\*NAS1149D0863.J\***

Washer

\*\*

14-5-27

DAS  
31  
9-89

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

79

125484

79

ST510a

800

125268

600

125635

200

DAS  
26  
9-89

2x

NAS1515H3L

Purchased

No

230

Each

519.0000 4 4

**\*NAS1515H3I \***

Washer

\*\*

gl 14/05/26

Location

Loc Qty

Loc Code

FG

36

102472

36

ST297

483

m127831

183

m128976

300

xv

NAS1611-005

Purchased

No

230

Each

136.0000 8 8

**\*NAS1611-005\***

O-RING

\*\*

gl 14/05/26

Location

Loc Qty

Loc Code

FP001

136

m126974

136

x8

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Shop Packet Print

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# Picklist Print

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May-12-14 11:52:27 AM

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

NAS1611-010

Purchased

No

230

Each

175.0000

Start Qty: 1.00

8

8

Required Qty: 1.00

**\*NAS1611-010\***

O-RING

\*\*

*WLOSLZC*

Location

Loc Qty

Loc Code

FP001

175

m126988

3

m127813

4

m128375

160

m128388

8

*x8*

D2744

Manufactured

No

110

Each

34.0000

1

1

**\*D2744\***

Cap

\*\*

*BE14-05-08*

Location

Loc Qty

Loc Code

LG001

34

*115440*

34

110

Each

11.0000

1

1

D2600-3-BENT

Manufactured

No

**\*D2600-3-BENT\***

Extrusion Bent

\*\*

*BE14-05-07*

Location

Loc Qty

Loc Code

LG

9

*113364*

9

LG002

2

112976

2

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Shop Packet Print

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# Picklist Print

May-12-14 11:52:27 AM

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

D2743

Manufactured No

160 Each

Start Qty: 1.00  
228.0000 8 8

Required Qty: 1.00

**\*D2743\***

Crossbolt Spacer

\*\*

*8/14-05-14*

Location	Loc Qty	Loc Code
LG	227	
111570	8	
112729	121	
114873	98	
LG001	1	
109799	1	

D2739

Manufactured No

160 Each

8.0000 1 1

**\*D2739\***

350 I Beam

\*\*

*14-5-12*

Location	Loc Qty	Loc Code
LG	8	
111094	2	
113252	1	
117803	5	

ALS4-1032-225

AELS8-1032-225 Purchased

No

230 Each

994.0000 4

**\*ALS4-1032-225\***

Rivnut

\*\*

*14-05-12*

Location	Loc Qty	Loc Code
FG	30	
M127028	30	
FP001	672	
M128649	672	
ST280	266	
M127028	10	
M128179	256	
st555	26	
M127092	26	

# Picklist Print

May-12-14 11:52:27 AM

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/15/14

Required Date: 5/20/14

AN8C35A Purchased No 230 Each 65.0000 Start Qty: 1.00 Required Qty: 1.00  
1 1  
**\*\***                                            
Bolt **\*AN8C35A\***                                          

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	
121275	4	
FP001	61	
m126293	29	
m127823	32	

AN6C44A Purchased No 230 Each 119.0000 Start Qty: 4 Required Qty: 4  
4 4  
**\*\***                                            
Bolt **\*AN6C44A\***                                          

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
103964	2	
ST341	28	
m128319	28	
ST505	89	
m128700	89	

MS21083C8 Purchased No 230 Each 191.0000 Start Qty: 1 Required Qty: 1  
1 1  
**\*\***                                            
Nut **\*MS21083C8\***                                          

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	11	
m127255	5	
m128119	6	
ST508	180	
m128798	180	

# Picklist Print

May-12-14 11:52:28 AM

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/15/14

Required Date: 5/20/14

D3631-1

Manufactured No

230 Each

Start Qty: 1.00  
8 8

Required Qty: 1.00

**\*D3631-1\***

Washer

**\*\***

*HL 11/05/26*

Location

Loc Qty

Loc Code

FP001

156

110258

16

111019

12

113164

28

115800

100

*x2*

NAS1149C0332R

Purchased

No

230 Each

6,586.000 4 4

**\*NAS1149C0332R\***

WASHER

**\*\***

*HL 11/05/26*

Location

Loc Qty

Loc Code

GA

905

125654

905

Return2014

41

122063

41

ST292

2490

m128591

2490

*x4*

st510

3150

m126319

61

m127306

2500

m127410

563

m127831

26

# Picklist Print

May-12-14 11:52:28 AM

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

D2745

Manufactured No

230

Each

Start Qty: 1.00  
150.0000 8 8

Required Qty: 1.00

**\*D2745\***

Bushing

\*\*

*HL 11/05/26*

Location

Loc Qty

Loc Code

ST017

150

107336

4

111554

20

113176

62

114874

64

*x9*

NAS1149C0832R

Purchased

No

230

Each

300.0000 1 1

**\*NAS1149C0832R\***

Washer

\*\*

*HL 11/05/26*

Location

Loc Qty

Loc Code

ST292

300

122441

33

m114915

117

m125807

150

*x1*

AN3C6A

Purchased

No

230

Each

1,305.000 4 4

**\*AN3C6A\***

Bolt

\*\*

*HL 11/05/26*

Location

Loc Qty

Loc Code

FG

10

122416

10

ST351

2

m128224

2

ST513

1293

m125709

293

m128769

1000

*x4*

# Picklist Print

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Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

MS21043-6

Purchased

No

230

Each

Start Qty: 1.00  
258.0000 4 4

Required Qty: 1.00

**\*MS21043-6\***

NUT

\*\*

*HL 14/05/14*

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

10

m127255

10

ST509

228

m127813

228

*24*

D3493-1

Manufactured

No

250

Each

221.0000 2 2

**\*D3493-1\***

Washer

\*\*

DAS  
26  
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

211

109105

159

112741

52

*2x*

MS21083C8

Purchased

No

250

Each

191.0000 2 2

**\*MS21083C8\***

Nut

\*\*

*14-5-27*

Location

Loc Qty

Loc Code

ST319

11

m127255

5

m128119

6

ST508

180

m128798

180

*2x*

DAS  
31  
9-89

DAS  
31  
9-89

DAS  
26  
9-89



# Picklist Print

May-12-14 11:52:28 AM

Page 13

Work Order ID: 118923

**\*118923\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/15/14

Required Date: 5/20/14

AN8C21A

Purchased

No

250

Each

69.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

**\*AN8C21A\***

Bolt

**\*\***

DAS

26

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST

2

123966

2

ST341

2

m127061

2

ST342

15

m128319

2

m128849

13

ST508

50

m127823

50

D2741

Manufactured

No

250

Each

46.0000

1

**\*D2741\***

Blade

**\*\***

1  
B1/5522

14-5-27

DAS

08

9-8

DAS

26

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

35

107206

2

113640

13

115522

20

May-12-14 11:52:28 AM

Shop Packet Print

Page 13

QTY -041*	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

118923 MJS  
1405-06

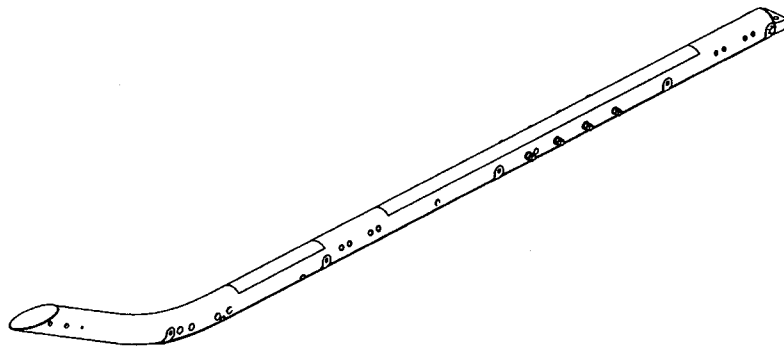
RELEASED  
2013-08-13  
WJP

#### GENERAL NOTES:

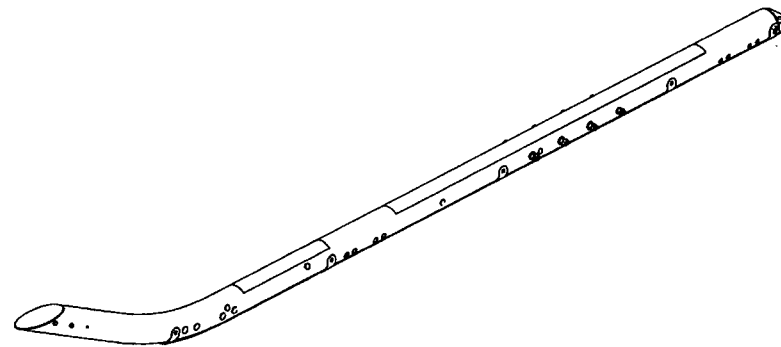
- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0" ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	JA		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.07.11		

DART AEROSPACE USA, INC.		REV. B
KENT, WA		SHEET 1 OF 11
DRAWING NO.	D4168	SCALE
TITLE	350 SKIDTUBE ASSEMBLY	NTS
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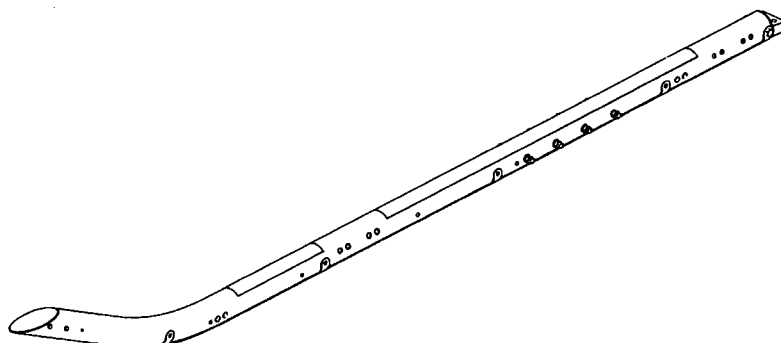
**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



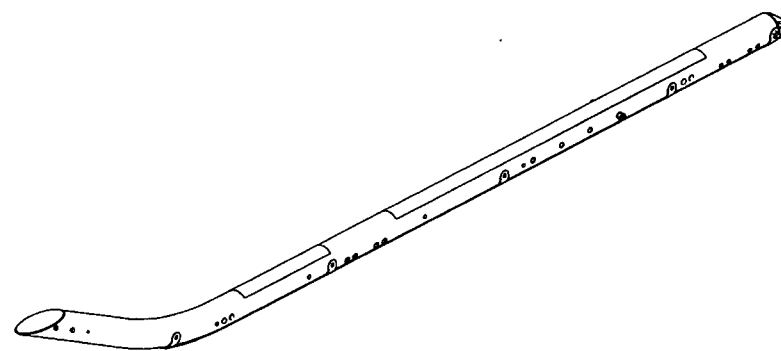
**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
*AW*

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>[Signature]</i>	KENT, WA	REV. B
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4168</b>	SHEET 2 OF 11
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	<b>13.07.11</b>		



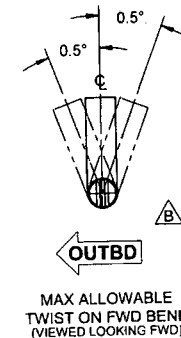
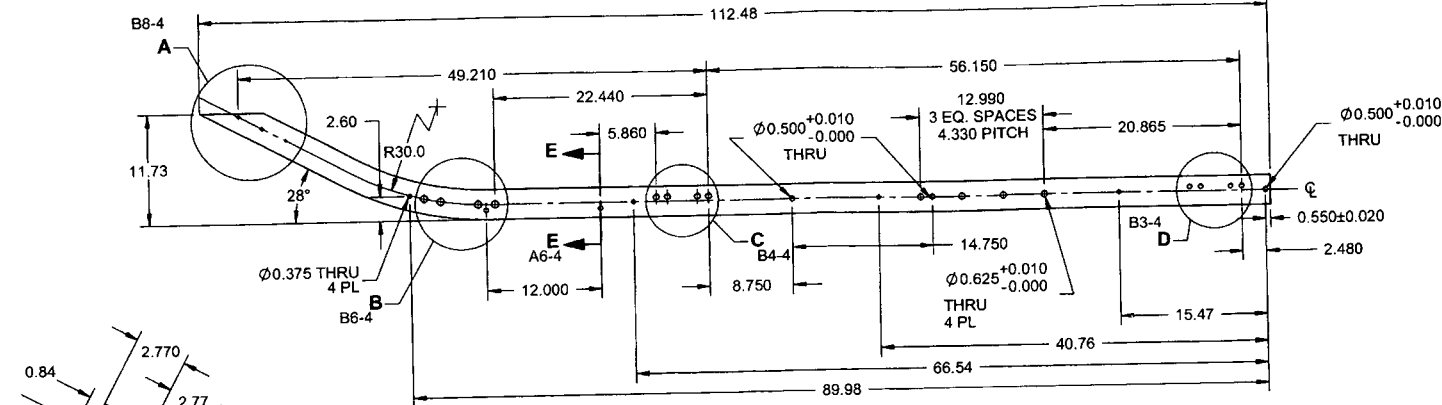
**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



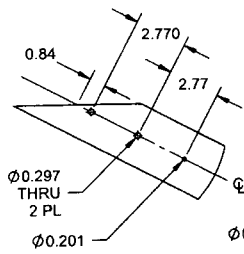
**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
 2013-08-13  
*MD*

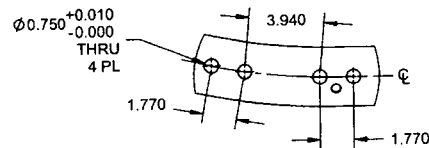
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>JB</i>	KENT, WA	REV. B
CHECKED	<i>JB</i>	DRAWING NO.	SHEET 3 OF 11
MFG. APPR.	<i>JB</i>	<b>D4168</b>	SCALE
APPROVED	<i>JB</i>	TITLE	NTS
DE APPR.	<i>JB</i>	<b>350 SKIDTUBE ASSEMBLY</b>	
DATE	<b>13.07.11</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



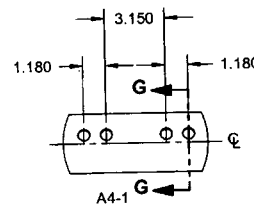
### D4168-1 LH SKIDTUBE



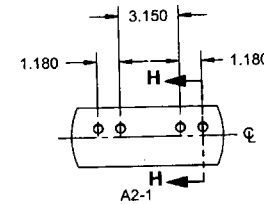
**DETAIL A**  
SCALE 2X



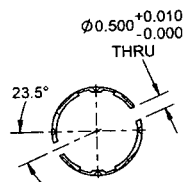
**DETAIL B**  
SCALE 2X



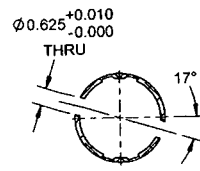
**DETAIL C**  
SCALE 2X



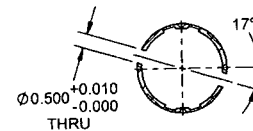
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



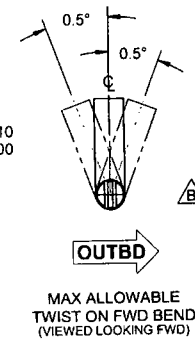
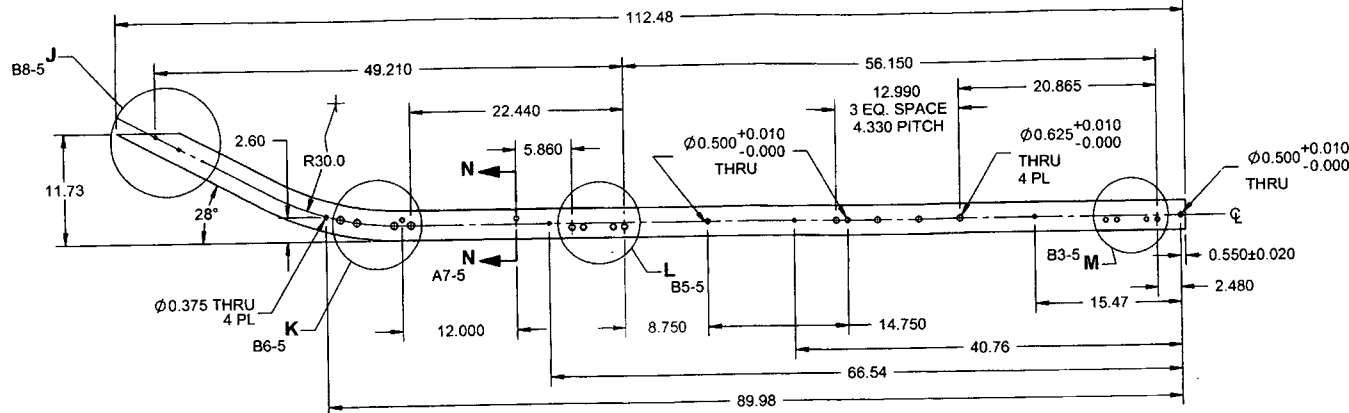
**SECTION H-H**  
SCALE 3X, 4 PL

**RELEASED**  
2013-08-13

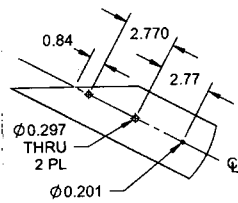
DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

**DART AEROSPACE USA, INC.**  
KENT, WA

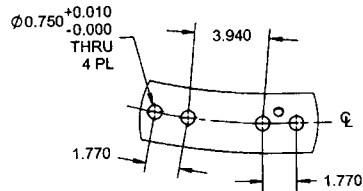
DRAWING NO. D4168  
TITLE 350 SKIDTUBE ASSEMBLY  
REV. A  
SHEET 4 OF 11  
SCALE NTS  
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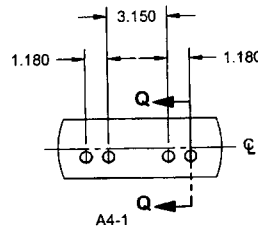
### D4168-2 RH SKIDTUBE



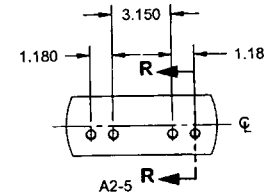
**DETAIL J**  
SCALE 2X



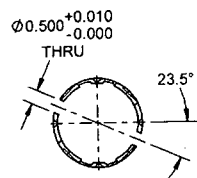
**DETAIL K**  
SCALE 2X



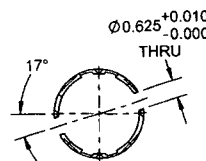
**DETAIL L**  
SCALE 2X



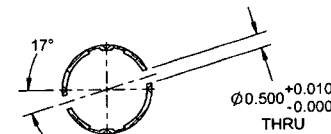
**DETAIL M**  
SCALE 2X



**SECTION N-N**  
SCALE 3X, 2 PL



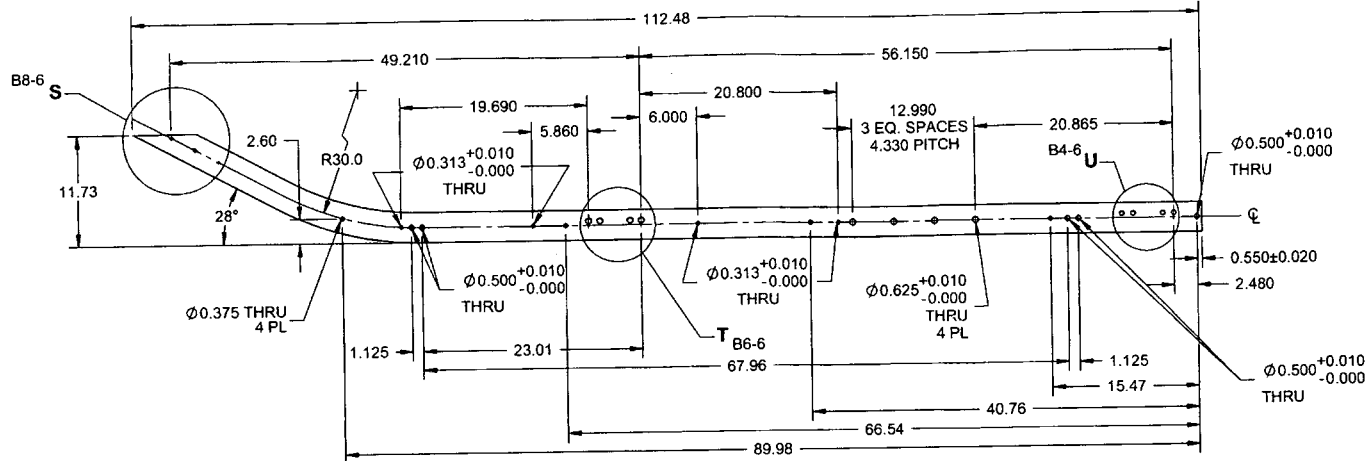
**SECTION Q-Q**  
SCALE 3X, 4 PL



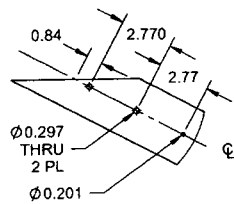
**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**  
2013-08-13  
JW

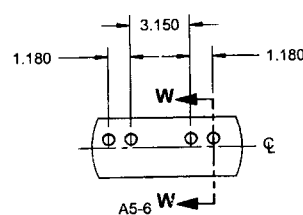
DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE 13.07.11		<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWING NO. <b>D4168</b>		REV. B SHEET 5 OF 11	
TITLE <b>350 SKIDTUBE ASSEMBLY</b>		SCALE NTS	
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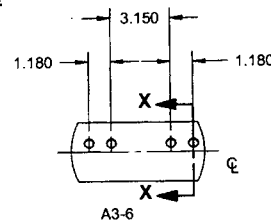
**D4168-3 LH SKIDTUBE**



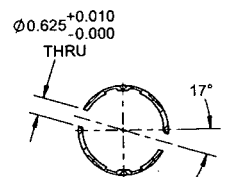
**DETAIL S**  
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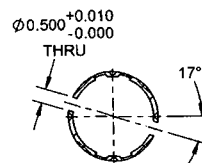
**DETAIL T**  
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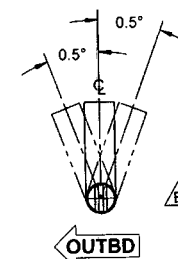
**DETAIL U**  
SCALE 2X



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL



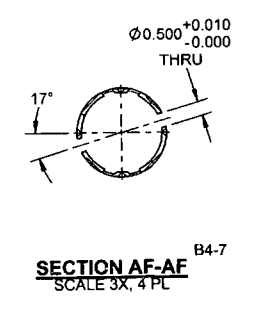
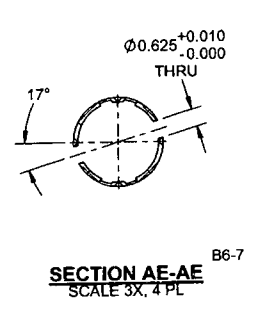
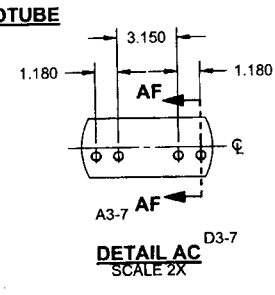
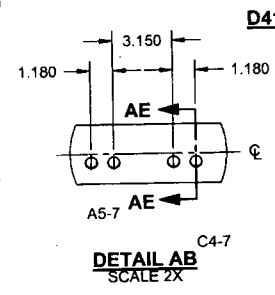
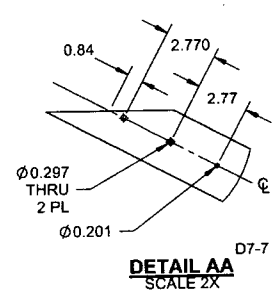
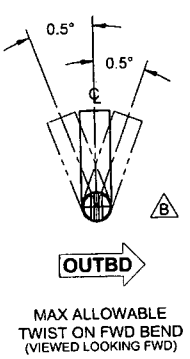
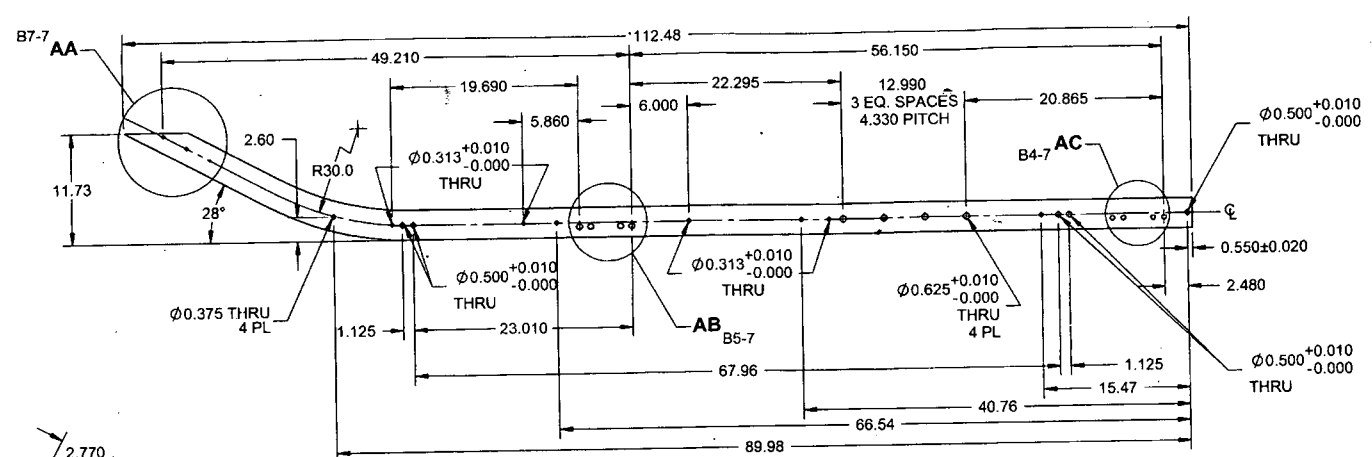
MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)

**RELEASED**  
2013-08-13

<b>DESIGN</b> DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE 13.07.11		<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. <b>D4168</b> TITLE <b>350 SKIDTUBE ASSEMBLY</b> SCALE NTS REV. B SHEET 6 OF 11	
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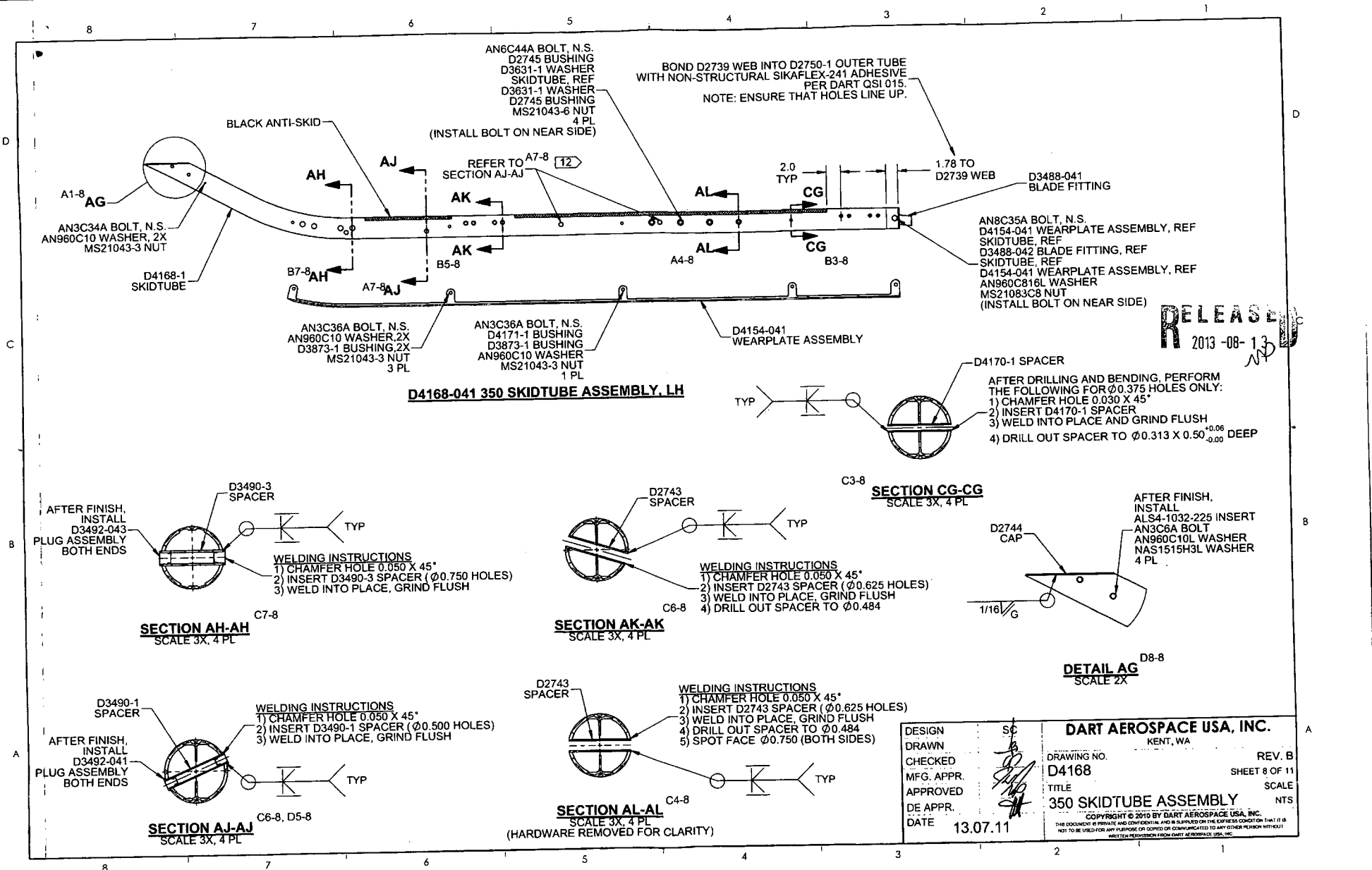
8 7 6 5 4 3 2 1



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2013-08-13

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4168	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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**RELEASED**  
R 2013-08-13

AN6C44A BOLT, F.S.  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL

BOND D2739 WEB INTO D2750-2 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

(INSTALL NUT ON NEAR SIDE)

REFER TO  
SECTION AP-AP

A7-9

2.0  
TYP

1.78 TO  
D2739 WEB

D3488-042  
BLADE FITTING

AN8C35A BOLT, F.S.  
D4154-041 WEARPLATE ASSEMBLY, REF  
SKIDTUBE, REF  
D3488-042 BLADE FITTING, REF  
SKIDTUBE, REF  
D4154-041 WEARPLATE ASSEMBLY, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON NEAR SIDE)



AN3C36A BOLT, F.S.  
AN960C10 WASHER, 2X  
D3873-1 BUSHING, 2X  
MS21043-3 NUT  
3 PL

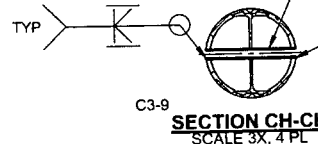
AN3C36A BOLT, F.S.  
D4171-1 BUSHING  
D3873-1 BUSHING  
AN960C10 WASHER  
MS21043-3 NUT  
1 PL

D4154-041  
WEARPLATE ASSEMBLY

**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

D4170-1 SPACER

AFTER DRILLING AND BENDING, PERFORM  
THE FOLLOWING FOR Ø0.375 HOLES ONLY:  
1) CHAMFER HOLE 0.030 X 45°  
2) INSERT D4170-1 SPACER  
3) WELD INTO PLACE AND GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.313 X 0.50<sup>+0.06</sup><sub>-0.00</sub> DEEP



**SECTION CH-CH**  
SCALE 3X, 4 PL

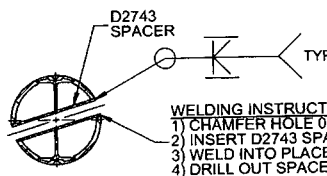
D2744  
CAP

D8-9

**DETAIL AM**  
SCALE 2X

AFTER FINISH,  
INSTALL  
ALS4-1032-225 INSERT  
AN3C6A BOLT  
AN960C10L WASHER  
NAS1515H3L WASHER  
4 PL

1/16<sup>1/6</sup>



**SECTION AQ-AQ**  
SCALE 3X, 4 PL

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø0.484

C5-9

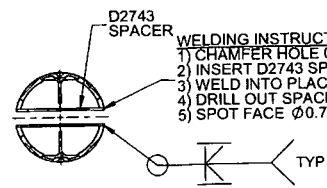
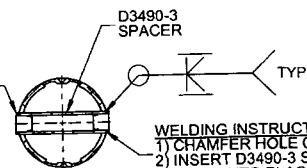
WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-3 SPACER (Ø0.750 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

C7-9

**SECTION AN-AN**  
SCALE 3X, 4 PL

AFTER FINISH,  
INSTALL  
D3492-043  
PLUG ASSEMBLY  
BOTH ENDS



**SECTION AR-AR**  
SCALE 3X, 4 PL

(HARDWARE REMOVED FOR CLARITY)

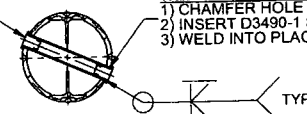
WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

C6-9, D5-9

**SECTION AP-AP**  
SCALE 3X, 4 PL

AFTER FINISH,  
INSTALL  
D3492-041  
PLUG ASSEMBLY  
BOTH ENDS



DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE

13.07.11

**DART AEROSPACE USA, INC.**

KENT, WA

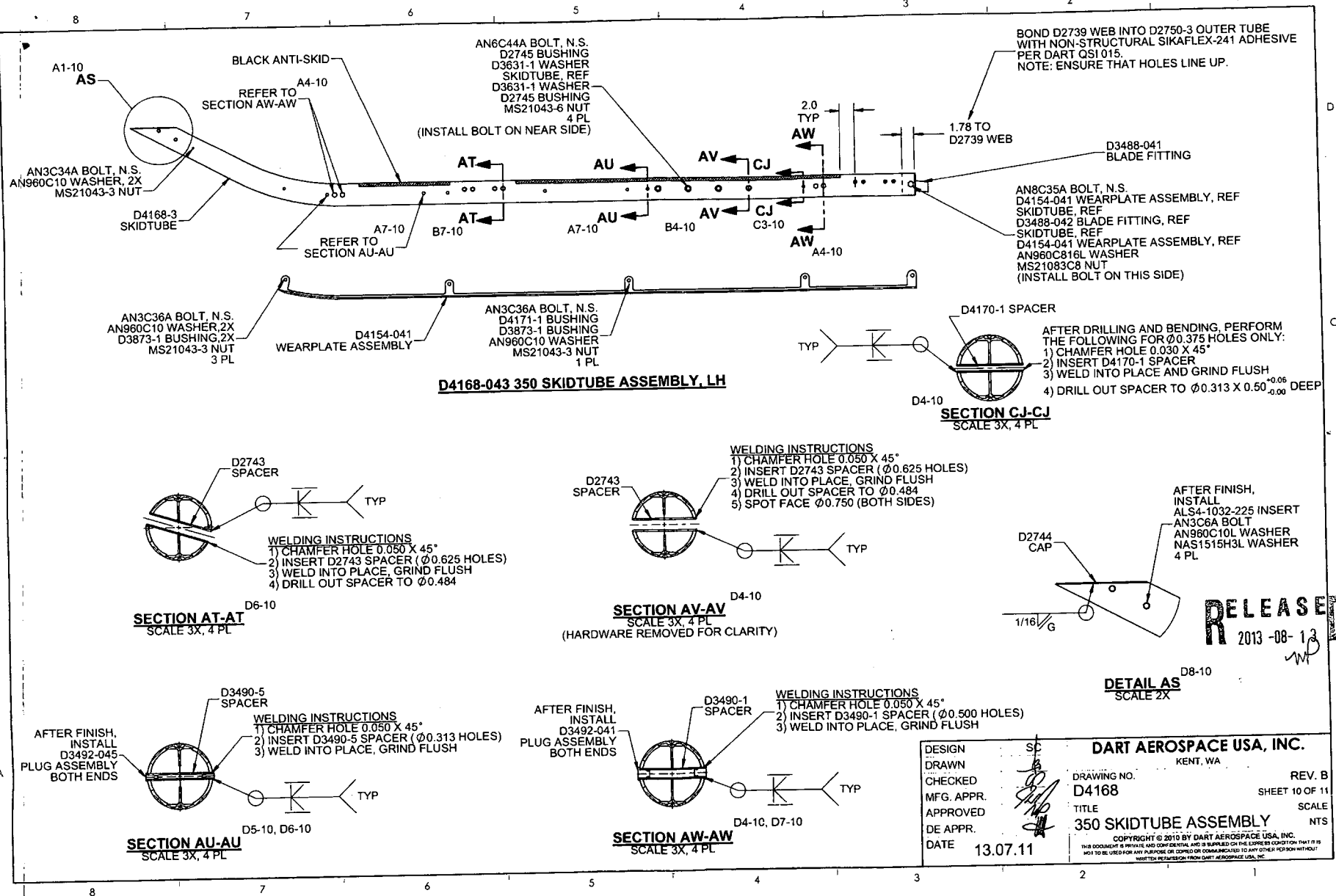
DRAWING NO.  
D4168

TITLE

350 SKIDTUBE ASSEMBLY

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REV. B  
SHEET 9 OF 11  
SCALE  
NTS



RELEASED  
2013-08-13



DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>[Signature]</i>	KENT, WA	REV. B
CHECKED	<i>[Signature]</i>	DRAWING NO.	SHEET 11 OF 11
MFG. APPR.	<i>[Signature]</i>	D4168	SCALE
APPROVED	<i>[Signature]</i>	TITLE	NTS
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	
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